

SAGE

## Work Order ID 52951

October 19, 2009 11:50:27 AM

Page 1

Item ID: D3983-047

Accept

Setup Start

Revision ID: A

Stop

Item Name: Closeout Attachment

Start Date: 10/19/09 Start Qty: 1.00

Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: PODate: 02/10/19 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3983

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3983-7

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B 9-10-20

E 305/10/20

(3)

B 9-10-20

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00



Quality Control •





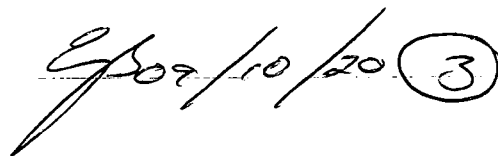



# Work Order ID 52951

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Item ID: D3983-047 Accept  Setup Start   
Revision ID: A Stop   
Item Name: Closeout Attachment  
Start Date: 10/19/09 Start Qty: 1.00  Cust Item ID:  
Required Date: 10/23/09 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 278 09/10/20 0.00							
130  Small Fab Small Fab	Memo 1- C'sink holes as per dwg 2- Deburr if necessary	0.00 0.00							
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 278 09/10/20 0.00							




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Item ID: D3983-047	Accept		Setup Start	
Revision ID: A			Stop	
Item Name: Closeout Attachment				
Start Date: 10/19/09	Start Qty: 1.00		Cust Item ID:	
Required Date: 10/23/09	Req'd Qty: 1.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	BR 09-10-20			3			
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	el 09/10/20			X3	0		
170  Small Fab Small Fab	 Memo 1- Assemble anchor nuts as per dwg	0.00 0.00							EP 09/10/21 3

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Item ID: D3983-047

Accept

Setup Start

Revision ID: A

Stop

Item Name: Closeout Attachment

Start Date: 10/19/09 Start Qty: 1.00

Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	⇒ 8 or 10/21			(X3)	/		
190 Packaging Packaging	Identify as per dwg & Stock Location: 139  Memo send to Harvey ECN 09-670	0.00  0.00	1						ENG 0106 OCT
200 QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							09/10/23 MF 09-10-23

# Picklist Print

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Page 1  
2

Work Order ID: 52951

Parent Item: D3983-047

Parent Item Name: Closeout Attachment


Comments:

Start Date: 10/19/09

Required Date: 10/23/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	96.5419	0.0398			
												
6061-T6 .040 Sheet												

189-10-20

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

96.5419

100742

3.3

102723

7.93

105842

12

106747

9.2116

107461

12.4674

109396

22.28

111224

27.8529

19380

1.5

107461

MS21059L3

Purchased

No

170

Each

425.0000

2.0000



Nut Plate



Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

425

109962

11

111925

414

9/30/10/21

6

# Picklist Print

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Page 2

Work Order ID: 52951

Parent Item: D3983-047

Parent Item Name: Closeout Attachment

Comments:

Start Date: 10/19/09

Required Date: 10/23/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS20426AD3-3 Purchased

No

170

Each

7,861.000

4.0000



RIVET



*Ep 09/10/21*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7861

104374

3861

110398

4000

*M7681 (12)*

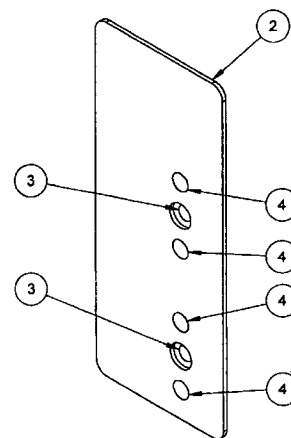
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Shop Packet Print

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ITEM	QTY. -047	PART NUMBER	DESCRIPTION
1	X	D3983-047	CLOSEOUT ATTACHMENT
2	1	D3983-7	PLATE
3	2	MS21059L3	ANCHOR NUT
4	4	MS20426AD3-4	RIVET



**D3983-047 CLOSEOUT ATTACHMENT**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52940

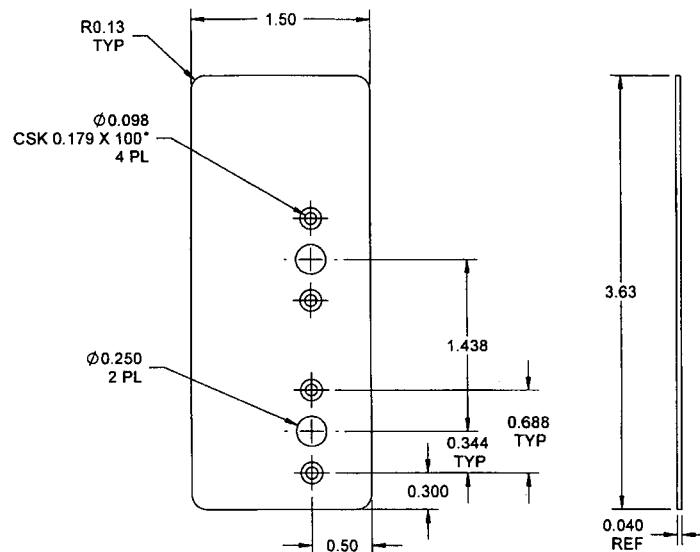
52951

**RELEASED**  
2009-10-13  
MD

**NOTES:**  
1) MATERIAL: SEE BOM  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-047" AND B/N USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT: 0.03 lbs

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3983	SHEET 5 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CLOSE OUT KIT	NTS
DATE	09.09.09	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	





**D3983-7 PLATE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52951

**RELEASED**  
2009-10-13  
*MD*

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.040
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.02 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3983</b>	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		<b>CLOSE OUT KIT</b>	NTS
DATE	09.09.09	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	